

Ship: Sept 29

Work Order ID 164955

164955

U/R

Page 1

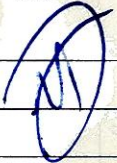
Thursday, August 10, 2017 12:01:24 PM

Item ID: D4842-041 Accept *N900040100* Setup Start *NS1*
Revision ID: URF 16-692 Stop *NS2*
Item Name: Lower Cutter Assembly

Start Date: 9/5/2017 Start Qty: 3.00 Cust Item ID:
Required Date: 9/21/2017 Req'd Qty: 3.00 Customer:

Reference:

5/17/08/10 *3*
3
Manufacturer to concession 400000061486

Approvals: Process Plan:  Date: AUG 10 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4842	REV B U/R

110	Pick Kit	0.00							
110									
Packaging	Memo	0.24							
Packaging									
120		0.00							
120									
Small Fab	Memo	2.57							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces.								
	A/R LOCTITE 598: _____								

130	QC5- Inspect part completeness to step on W/O	0.00							
130	* Record thickness of assembly								
QC	Memo	0.06							

Quality Control

5
17/08/10

* ID Part with concession Number

POSITIVE RECALL
EFFECTIVE 17/08/10 AUTH 5
RELEASED _____ DATE _____

Enter Manufacture to concession attachment

CANCEL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 164955

Thursday, August 10, 2017 12:01:24 PM

164955

Page 2

Item ID: D4842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-692 Stop ***NS2***
Item Name: Lower Cutter Assembly
Start Date: 9/5/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 9/21/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.03							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.30							



SEP 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, August 10, 2017 12:01:24 PM

Page 1

Work Order ID: 164955

164955

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 9/5/2017

Required Date: 9/21/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1 *D4839-1* Blade		Manufactured	No				Each	0.0000	**	6			
D4842-1 *D4842-1* Lower Cutter Deflector		Manufactured	No				Each	1.0000	**	3			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK035			1						
				159671			1						
D4842-3 *D4842-3* Lower Cutter Body, LH		Manufactured	No				Each	8.0000	**	3			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK129			2						
				159676			2						
				qrtn			6						
				140906			6						
D4842-4 *D4842-4* Lower Cutter Body, RH		Manufactured	No				Each	4.0000	**	3			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK129			2						
				159677			2						
				qrtn			2						
				142317			2						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Picklist Print

Thursday, August 10, 2017 12:01:24 PM

Page 2

Work Order ID: 164955

164955

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 9/5/2017

Required Date: 9/21/2017

Start Qty: 3.00

Required Qty: 3.00

MS21042L08

Purchased

No

Each

813.0000

18

MS21042L 08

Nut

Location

Loc Qty

Loc Code

GA

94

m135978

94

ST303

719

m127410

10

m133922

40

m137736

42

m137951

200

m138045

102

m138207

125

m138237

200

MS27039-08-19

Purchased

No

Each

245.0000

18

MS27039-08-19

Screw

Location

Loc Qty

Loc Code

GA

30

m135948

26

m137178

4

ST277

215

m137464

11

m138045

54

m138207

50

m138237

100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

Thursday, August 10, 2017 12:01:24 PM

Page 3

Work Order ID: 164955

164955

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 9/5/2017

Required Date: 9/21/2017

Start Qty: 3.00

Required Qty: 3.00

NAS1149FN832P

Purchased

No

Each

1,496.000

36

NAS1149FN832P

Washer

Location

Loc Qty

Loc Code

GA

850

M135058

208

M136182

40

M136866

43

M137820

559

ST263

646

M137412

86

M137820

560

Thursday, August 10, 2017 12:01:24 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



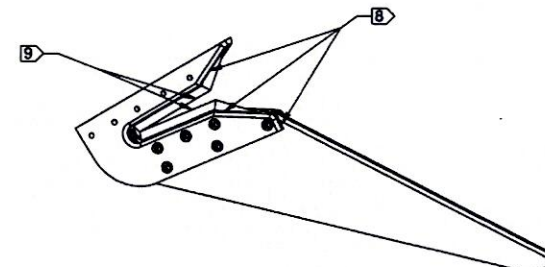
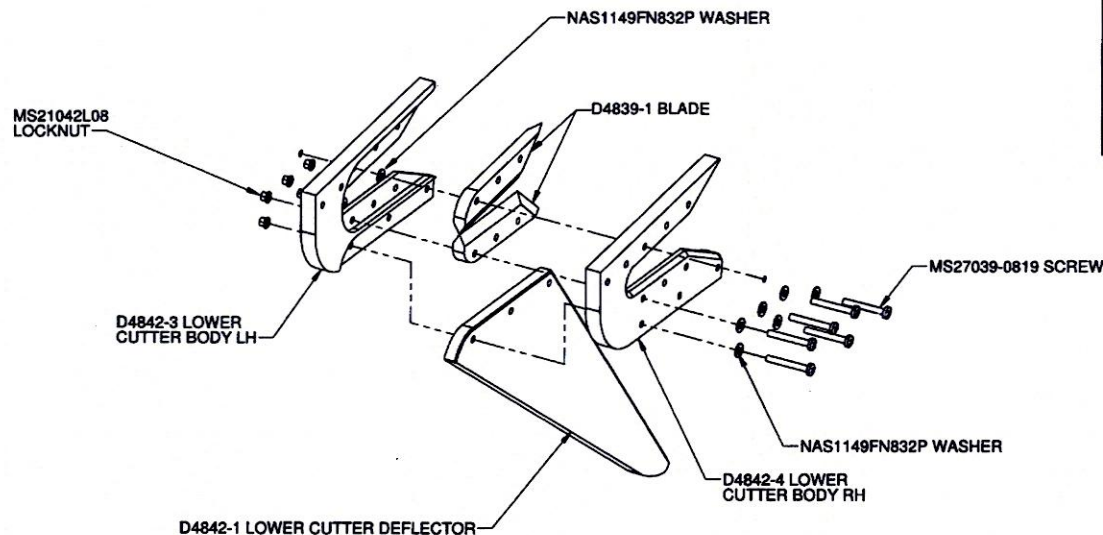
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	6	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NAS1149FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164955
AUG 10 2017

D4842-041 LOWER CUTTER ASSEMBLY

UNDER REVIEW

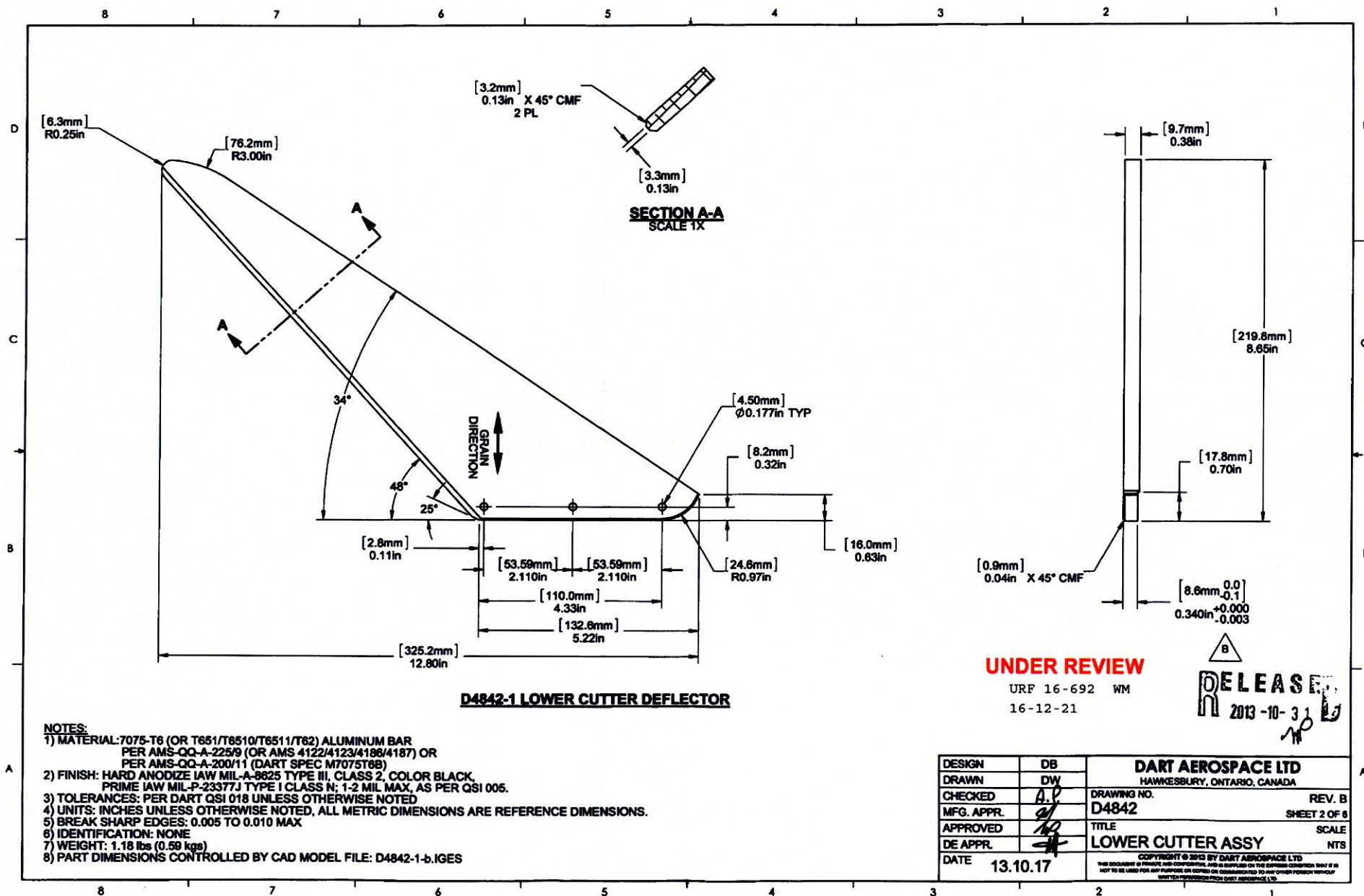
URF 16-692 WM
16-12-21

RELEASED
2013-10-31

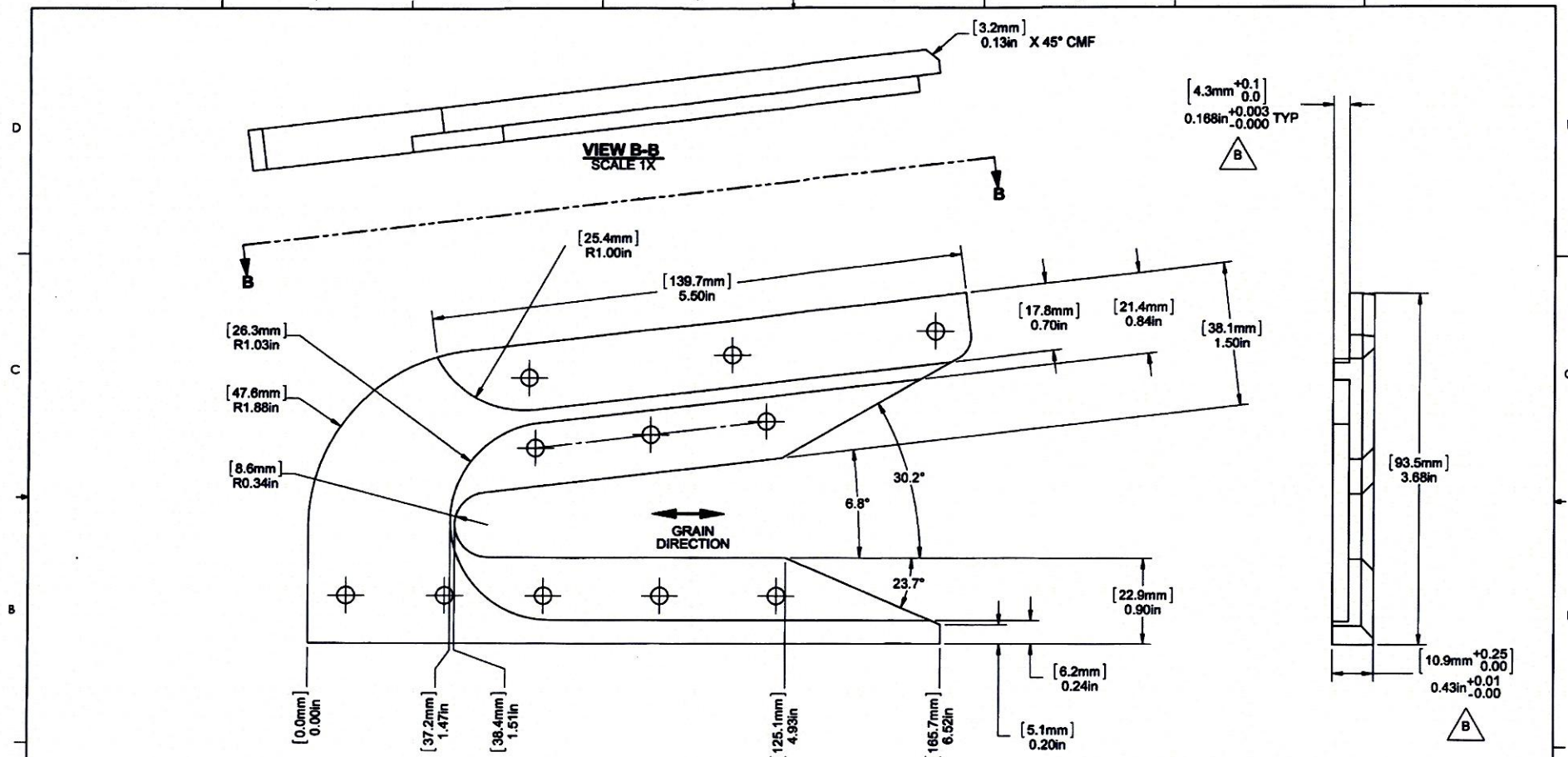
B	CORRECT TOLERANCES (ZN B1-2) (ZN B1-3, D2-3)	DW	13.10.17
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	21	D4842	SHEET 1 OF 6
APPROVED	12	TITLE	SCALE
DE APPR.	12	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 2.79 lbs (1.26 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.



8 7 6 5 4 3 2 1



VIEW B-B
SCALE 1X

D4842-3 LOWER CUTTER BODY LH

UNDER REVIEW

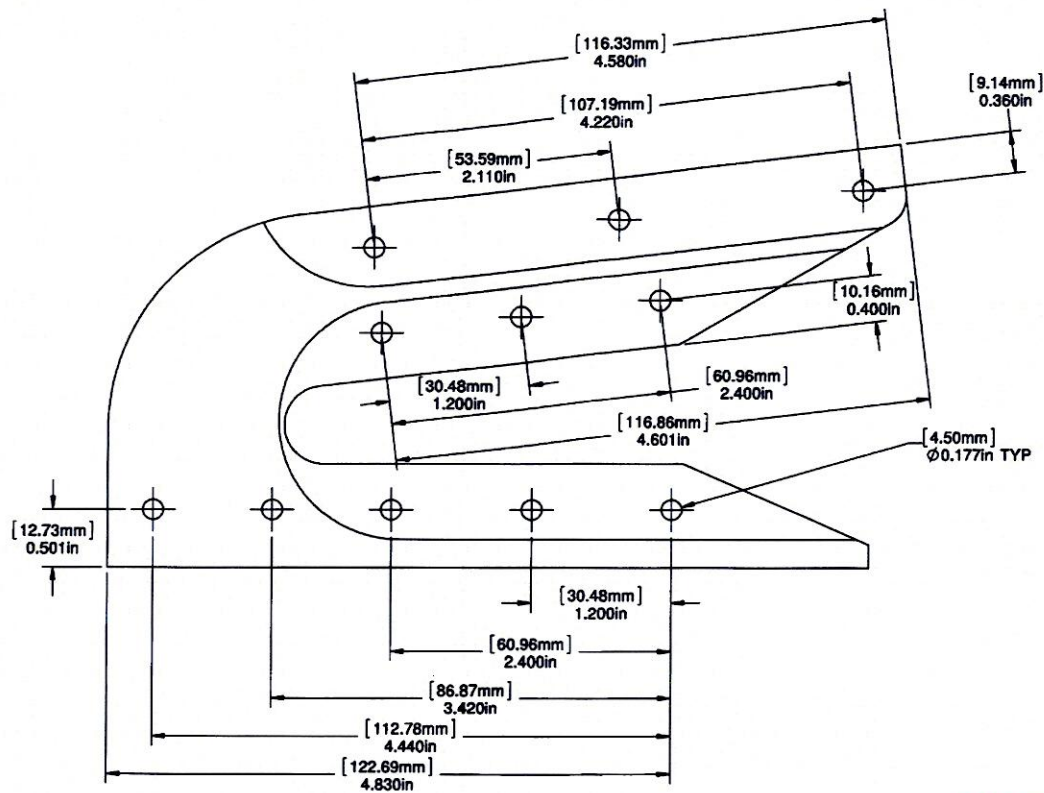
URF 16-692 WM
16-12-21

RELEASED
2013-10-31

- NOTES:
- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T68)
 - 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, AS PER QSI 017;
PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.49 lbs (0.22 kgs)
 - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4842-3-b.IGES

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	2/1	D4842	SHEET 3 OF 6
APPROVED	2/1	TITLE	SCALE
DE APPR.	2/1	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



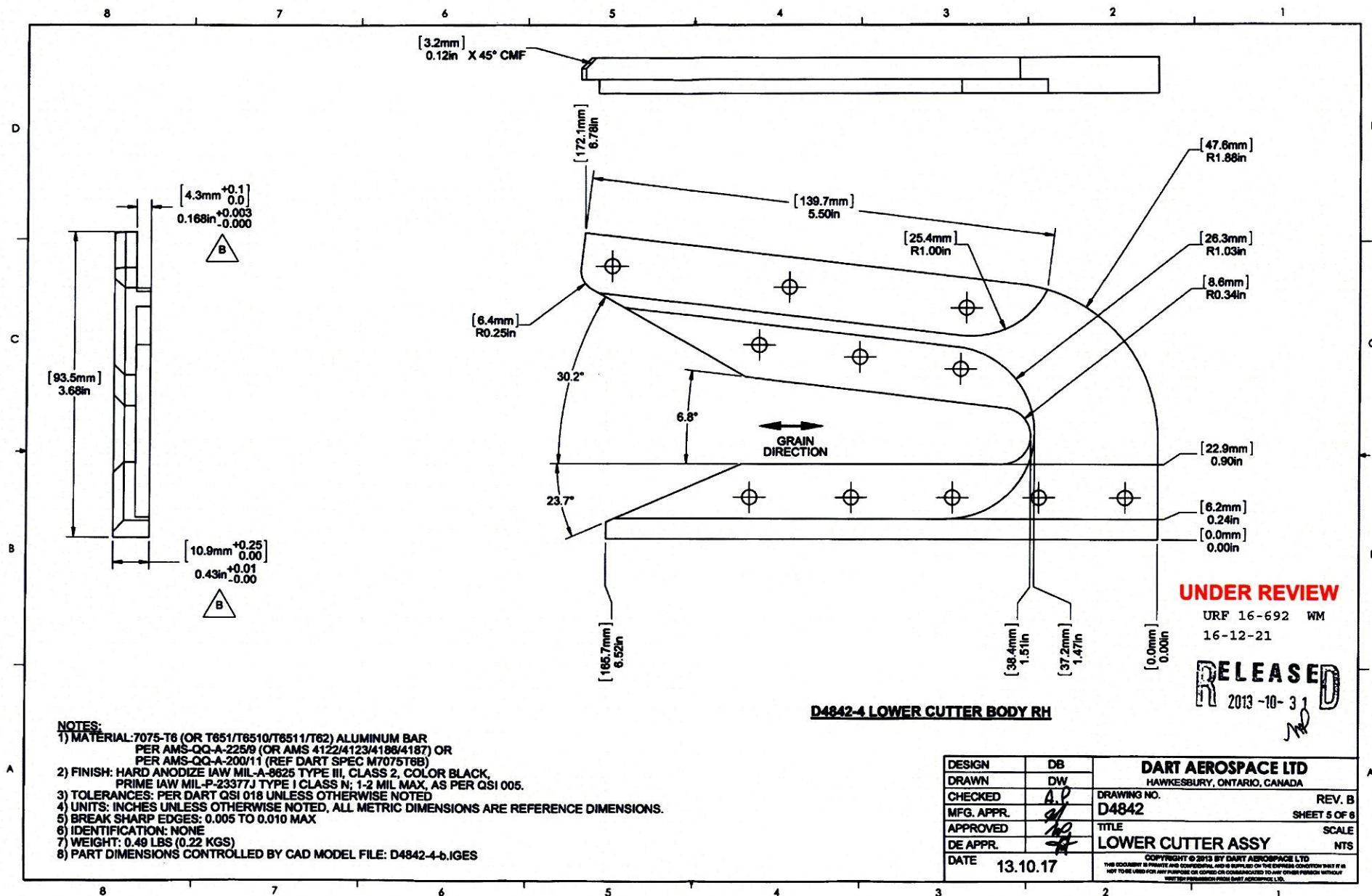
D4842-3 LOWER CUTTER BODY LH
(AUXILIARY VIEW)

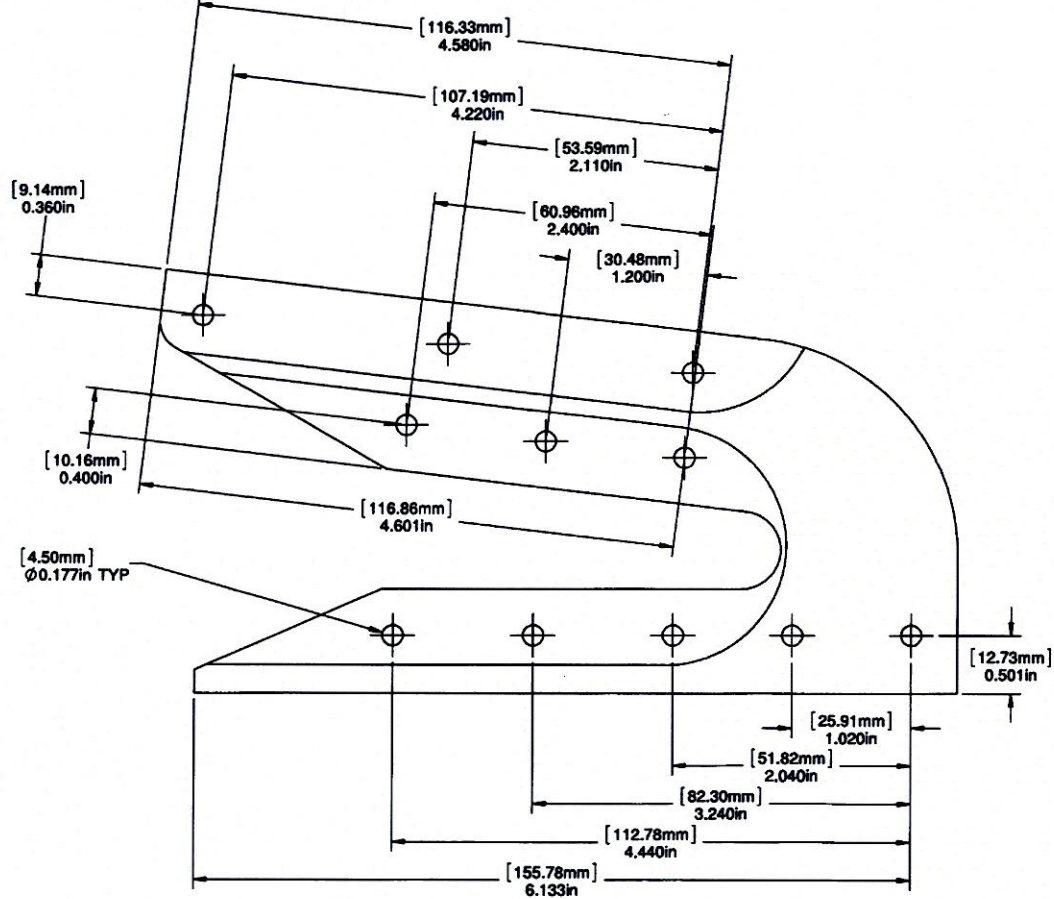
UNDER REVIEW

URF 16-692 WM
16-12-21

RELEASE
2013-10-31

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	2/	D4842	SHEET 4 OF 6
APPROVED	1/	TITLE	SCALE
DE APPR.	1/	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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D4842-4 LOWER CUTTER BODY RH
(AUXILLIARY VIEW)

UNDER REVIEW

URF 16-692 WM
16-12-21

RELEASE
2013-10-31

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	al	D4842	SHEET 6 OF 8
APPROVED	16/1	TITLE	SCALE
DE APPR.	16/1	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OTHER OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

		Supplier Concession				PAGE 1 of 2	PLANT Leonardo Helic. - Vergiate	
Supplier NC N.	AWC 006/01		Date	02.02.2017		AW Concession	400000061786	
P/N	6F9540V00231		Grade/Category	NC		Purchase Order	4801373666	
Part Description	PROTECTR, CCP ASSY LOWER		Batch Quantity	20,000		Drawing Issue		
AW NC	GUIDO BRUSCINO		Defective Quantity	20,000		A/C Type/Model	AW6	
Supplier	DART AEROSPACE LTD		Contract					
Defect FO01 - Wrong dimensions - * 02.02.2017 09:40:16 GUIDO BRUSCINO (40067) * see supplier document attached - B/N quantities and PO's listed in the Cause of Defect								
Repetitiveness (same P/N - Defect Code) NO ☒ YES ☐ Follow								
ENGINEERING Evaluation and Proposal								
Engineering Evaluations, including Specialist inputs: * 10.02.2017 18:01:48 MARCELLO STEFANELLI (9273) * The part is acceptable with the action proposed by the supplier applied.			Investigation Report n.			Compliance Report n.		
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B								
Defect effect						Limitations		
	Before Repair		After Repair					
Safety	☐	YES	☐	YES	☐	☐ YES (to specificity) ☒ NO		
Life or Duration	☐	YES	☐	YES	☐			
Strenght	☐	YES	☐	YES	☐			
Performances	☐	YES	☐	YES	☐			
Interchangeability	☐	YES	☐	YES	☐			
Reliability	☐	YES	☐	YES	☐			
Maintainability	☐	YES	☐	YES	☐			
Installability	☒	YES	☐	YES	☒			
Testability	☐	YES	☐	YES	☐			
Only Appearance	☐	YES	☐	YES	☐			
No Effect	☐	YES	☐	YES	☐			
Repair Proposal:					Decision			
* 10.02.2017 18:01:48 MARCELLO STEFANELLI (9273) * See attached supplier document.					☐ Use rep. with spec.repair(not yet applied) ☒ Use repaired with known repair(yet applied) ☐ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO		
Mark part with Concession		☒ NO ☐ YES		Method :				
ATE	MARCELLO STEFANELLI		CPE			Date	10.02.2017	
Checks and tests to be performed								
Repair registration with repair WO ☒ Number:								
Repair Evaluation:								
Final Decision								
S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
Not Serialized	Use As Is (Q.ty)		Use Repaired (Q.ty)		Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative		
Signature	MARCELLO STEFANELLI							
Date	10.02.2017							

		Supplier Concession				PAGE 2 of 2	PLANT Leonardo Helic. - Vergiate
Supplier NC N.	AWC 006/01	Date	02.02.2017	AW	400000061786	Purchase Order	4801373666
DEFECT 0001							
		FO01	Wrong dimensions				
attachment							

Manuf. Doc. N.	AWC 006	Date		AW Doc. N.		Purchase Order	4800671131 4800722284 4801147764 4801186922 4801218851 4801288960 4801373666
AW P/N	6F9540V00231	S/N / Batch Number	B109195 Qty. (1) B133355 Qty. (2) B134314 Qty. (1) B134315 Qty. (1) B134842 Qty. (1) B137492 Qty. (1) B137355 Qty. (2) B137816 Qty. (1) B137818 Qty. (1) B137817 Qty. (1) B140379 Qty. (3) B140381 Qty. (2) B147002 Qty. (2) B150786 Qty. (1)	Grade	A	AW Drawing Issue	B

Description	Lower Cutter Assy	Batch Qty	20	Defective Qty	20
Manufacturer	Dart Aerospace	Model	AW169		

Defect(s) Description

Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 onto the Leonardo interface bracket.

Department	Inspector	Signature	Date
Quality	DAS 16 9-89		2017/02/01

Defect(s) Cause

The Lower Cutter body has a dimension of 10.9 +0.25/-0.00 mm. This dimension was reported as part of the approved FAI and has been met with all delivered product.

Department	Inspector	Signature	Date
Quality	DAS 16 9-89		2017/02/01

Corrective Action

Complete
Before

In order to mitigate the interference issue for Leonardo, Dart is proposing to remove sufficient material to make the overall installation dimension at 22.15 mm +0.05/-0.35.

Department	Inspector	Signature	Date
Quality	DAS 16 9-89		2017/02/01

For "MANUFACTURER" SUPPLIERS ONLY
ENGINEERING evaluation and proposal

Engineering evaluation

 Investigation report
 Compliance report

 n.....
 n.....

Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.3 mm max from each part will not impact the structural integrity of the lower cutter assembly. The dimension on the cutter body part D4842-3/-4 will be 10.80 +0.00/-0.200.

The dimension change of the two lower cutter body parts mating, plus the sealant, anodize and primer layers will be defined as a dimension of 22.15 +0.05/-0.35 mm on the assembled lower cutterbody and will be incorporated into the D4842 drawing for inspection.

	Defect effects		Limitations
	Before any repair	After any repair	
Safety	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☒ yes	☐ yes ☒ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal None			Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☒ Scrap
Concession Classification	☒ Major ☐ Minor		Submit after repair ☐ yes ☐ no